

**WHAT IS CLAIMED IS:**

1. An indexable insert adapted for turning, which comprises a nose cutting-edge having a nose radius  $R$ , a linear cutting edge, and a minor cutting edge formed between the nose cutting-edge and the linear cutting edge, wherein

the minor cutting edge comprises a first minor cutting edge having a radius  $R_a$  and a second minor cutting edge having a radius  $R_b$ , the first and second minor cutting edges successively extending from a nose tip to the linear cutting edge;

the nose cutting-edge and the first minor cutting edge are connected such that, at a connection point between an arc assumed by the nose cutting-edge and an arc assumed by the first minor cutting edge, a smaller intersectional angle  $\theta_x$  of a tangent  $T_{12}$  and a tangent  $T_{21}$  to the respective arcs is  $1^\circ$  or less;

the first minor cutting edge and the second minor cutting edge are connected such that, at a connection point between the arc assumed by the first minor cutting edge and an arc assumed by the second minor cutting edge, a smaller intersectional angle  $\theta_y$  of the tangent  $T_{21}$  and a tangent  $T_{22}$  to the respective arcs is  $1^\circ$  or less; and

wherein  $R_a > R$ ,  $R_a$  falls within a range of 3 mm to 20 mm, and  $R_b \geq 1.5R_a$ .

2. The indexable insert as claimed in claim 1, wherein the connection point between the arc assumed by the nose cutting-edge and the arc assumed by the first minor cutting edge projects outwardly in relation to the adjacent arcs, and the connection point between the arc assumed by the first minor cutting edge and the arc assumed by the second minor cutting edge projects outwardly in relation to the adjacent arcs.

3. The indexable insert as claimed in claim 1, wherein at least one of the angle  $\theta_x$  and the angle  $\theta_y$  is  $0^\circ$ .

4. The indexable insert as claimed in claim 1, wherein a central angle  $\theta_1$  of the arc assumed by the first minor cutting edge falls within a range of 2 degrees to 4 degrees.

5. The indexable insert as claimed in claim 1, wherein the arc assumed by the second minor cutting edge has a chordal length of 0.2 mm or more.

6. The indexable insert as claimed in claim 1, wherein the second minor cutting edge assumes the form of a straight line.

7. The indexable insert as claimed in claim 1, wherein an outwardly projecting arcuate cutting edge is provided at a connection point between the second minor cutting edge and the linear cutting edge.

8. A cutting tool comprising an indexable insert as claimed in claim 1 and a tool holder, the indexable insert being clamped on the tool holder.